



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5425-043
Job Sheet 196264



Part No: D5425-043

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly

Part Weight: 0 lbs

Job Created: 6/11/19

Due Date: 7/30/19

Type: Stock

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG D5425 REV.B IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER DWG
REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs		7/30/19	0.00	8.24	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		TF
							Skidtubes - 6		
							Skidtubes - 7		
120	HAAS 4 Axis - B4B	1 pcs		7/30/19	1.00	22.77	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	1 pcs		7/30/19	0.00	0.00	QC 2 - 1		gmm L 19/10/19
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S193253

Part: D5425-043

Job No: 196264

Serial No/Batch: S193253

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/24/19

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						QC 2 - 49	Marie 19/10/27						
						QC 2 - 50							
						QC 2 - 51							
						QC 2 - 52							
						QC 2 - 57							
						QC 2 - 62							
						QC 2 - 63							
						QC 2 - 8							
						QC 2 - 66							
						QC 2 - 64							
						QC 2 - 65							
						QC 2 - 5							
						QC 2 - 71							
						QC 2 - 73							
						QC 2 - 69							
						140 QC 8		1	7/30/19	0.00	0.00	QC 8 - 12	Marie 19/10/27
						pcs						QC 8 - 14	
					QC 8 - 17								
					QC 8 - 20								
					QC 8 - 25								
					QC 8 - 3								
					QC 8 - 32								
					QC 8 - 33								
					QC 8 - 35								
					QC 8 - 39								
					QC 8 - 4								
					QC 8 - 44								
					QC 8 - 45								
					QC 8 - 49								
					QC 8 - 58								
					QC 8 - 8								
					QC 8 - 9								
					QC 8 - 68								
					QC 8 - 67								
					QC 8 - 1 (A)								
					QC 8 - 47								
					QC 8 - 40								
					QC 8 - 52								
					QC 8 - 23								
					QC 8 - 57								
150 Handfinish - 1-1 Chemical-B4B	1	7/30/19	0.00	0.24	Handfinish - 1 - 1 - B4B	OCT 30 2019							
					Handfinish - 1 - 2 - B4B								
					Handfinish - 1 - 3 - B4B								
					Handfinish - 1 - 4 - B4B								
					Handfinish - 1 - 5 - B4B								
					Handfinish - 1 - 6 - B4B								
					Handfinish - 1 - 7 - B4B								
					Handfinish - 1 - 8 - B4B								
					Handfinish - 1 - 9 - B4B								
					Handfinish - 1 - 10 - B4B								
					Handfinish - 1 - 11 -								

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				B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
160 QC 7	1	7/30/19	0.00 0.00	QC 7 - 10		
	pcs			QC 7 - 13		
				QC 7 - 14		
				QC 7 - 15		
				QC 7 - 17		
				QC 7 - 18		
				QC 7 - 19		
				QC 7 - 2		
				QC 7 - 28		
				QC 7 - 3		
				QC 7 - 30		
				QC 7 - 34		
				QC 7 - 36		
				QC 7 - 37		
				QC 7 - 41		
				QC 7 - 47		
				QC 7 - 48		
				QC 7 - 51		
				QC 7 - 58		
				QC 7 - 59		
				QC 7 - 60		
				QC 7 - 9		
				QC 7 - 68		
				QC 7 - 50		
				QC 7 - 67		
				QC 7 - 40		
				QC 7 - 24		
				QC 7 - 43		
170 Skidtubes - Bend - 2 - B4B	1	7/30/19	0.50 2.63	Skidtubes - Bend - B4B		
	pcs					
180 QC 5	1	7/30/19	0.00 0.00	QC 5 - 10		
	pcs			QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		

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BE

					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
190 Skidtubes - 2 - B4B	1 pcs	7/30/19	0.00 8.24	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		MBG
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
200 QC 5	1 pcs	7/30/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		DAS NOV 05 2019 68
				QC 5 - 9		9-89
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
210 Handfinish - 6-1- Touch Up- B4B	1 pcs	7/30/19	0.00 0.24	Handfinish - 6 - 1 - B4B		
				Handfinish - 6 - 2 - B4B		
				Handfinish - 6 - 3 - B4B		9 NOV 05 2019
				Handfinish - 6 - 4 - B4B		
				Handfinish - 6 - 5 - B4B		
				Handfinish - 6 - 6 - B4B		
				Handfinish - 6 - 7 - B4B		
				Handfinish - 6 - 8 - B4B		
				Handfinish - 6 - 9 - B4B		
				Handfinish - 6 - 10 - B4B		
				Handfinish - 6 - 11 - B4B		
				Handfinish - 6 - 12 - B4B		
				Handfinish - 6 - 13 - B4B		
				Handfinish - 6 - 14 - B4B		
				Handfinish - 6 - 15 -		

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				B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
220 QC 7	1 pcs	7/30/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	MGG
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
230 Skidtubes - 3 - B4B	1 pcs	7/30/19	0.00 8.24	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MGG
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
240 QC 5	1 pcs	7/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	

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6/11/2019

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						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	DAS NOV 08 2019 68
						QC 5 - 9	9-89
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
250 Handfinish - 6-2- Touch Up- B4B	1 pcs	7/30/19	0.00	0.33		Handfinish - 6 - 1 - B4B	
						Handfinish - 6 - 2 - B4B	
						Handfinish - 6 - 3 - B4B	NOV 08 2019
						Handfinish - 6 - 4 - B4B	
						Handfinish - 6 - 5 - B4B	
						Handfinish - 6 - 6 - B4B	
						Handfinish - 6 - 7 - B4B	
						Handfinish - 6 - 8 - B4B	
						Handfinish - 6 - 9 - B4B	
						Handfinish - 6 - 10 - B4B	
						Handfinish - 6 - 11 - B4B	
						Handfinish - 6 - 12 - B4B	
						Handfinish - 6 - 13 - B4B	
						Handfinish - 6 - 14 - B4B	
						Handfinish - 6 - 15 - B4B	
						Handfinish - 6 - 16 - B4B	
						Handfinish - 6 - 17 - B4B	
						Handfinish - 6 - 18 - B4B	
						Handfinish - 6 - 19 - B4B	
						Handfinish - 6 - 20 - B4B	
						Handfinish - 6 - 21 - B4B	
						Handfinish - 6 - 22 - B4B	
260 QC 7	1 pcs	7/30/19	0.00	0.00		QC 7 - 10	
						QC 7 - 13	
						QC 7 - 14	
						QC 7 - 15	
						QC 7 - 17	
						QC 7 - 18	
						QC 7 - 19	
						QC 7 - 2	DAS NOV 09 2019 81
						QC 7 - 28	9-89
						QC 7 - 3	
						QC 7 - 30	
						QC 7 - 34	

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					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
270	Spray Paint - 2 - B4B	1 pcs	7/30/19	0.00 0.50	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	RD 19-11-9
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
280	QC 14	1 pcs	7/30/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	BE B 19-11-11
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
282	Outsource - 11 - Paint	1 pcs	7/30/19		ATE003-VC	2
284	Packaging 2-1 - Receive - B4B	1 pcs	7/30/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	

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					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
286 QC 6	1 pcs	7/30/19	0.00	0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
290 Handfinish - 4-1-Assembly-B4B	1 pcs	7/30/19	0.00	0.24	Handfinish - 4 - 1 - B4B	
					Handfinish - 4 - 10 - B4B	BE B4B-11-11
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
300 QC 5	1 pcs	7/30/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS NOV 12 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	

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11/2019

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310 Packaging 3-1 - Stock - B4B	1 pcs	7/30/19	0.00	0.00	QC 5 - 40	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
320 QC 21 - SA	1 pcs	7/30/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21 NOV 13 2019
					QC 21 - SA - 53	5-35

Part Op 110 - 1-Cut tube to finished length as per Dwg. 2-Debur ends as per Dwg.
 Descriptions: 120 - 1-Machine as per Dwg. and Folio FB536 DWG REV: B FOLIO REV: A 2-Debur as per Dwg.
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 150 - 1-Scrub inside of tube with medium scotchbright.
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - 1-Bend Aft end of tube as per Dwg. and Folio . Insert Bending mandrel DT 10328 at 20.0" from aft end. Use buggy A,B,C. to stabilize tube. HEIGHT 2-Bend Forward end of tube as per Dwg. and Folio . Insert Bending mandrel DT 10328 at 12.0" from fwd end. Use buggy A,B,C To stabilize tube. HEIGHT 3-Record dimensions on work order.
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - 1-Drill remaining holes of DETAIL M, N, P. USING DT10340 A,B,C,D 2-Open holes to finished size as per Dwg. 3-Debur holes per QSI002 section 4.2.3 and blow out all chips from inside of tube.
 200 - (QC5- Inspect part completeness to step on W/O)
 220 - (QC7-Inspect Chemical Conversion Coat)
 230 - 1-Wet install crossbolt spacers of Section G-G. Swage to 0.437 as per Dwg. PRIMER B 5108160 Start Time: 10:30 Finish Time: 14:30 ***CURE TIME 6HRS. BEFORE PROCEEDING TO NEXT STEP*** 2-Swage crossbolt spacers of Section F-F to 0.313 as per Dwg. 3-Trim / Grind flush, deburr. 4-Identify per QSI 044 6.1
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Touch up alodine) ***DO NOT SUBMERGE TUBE IN DEOXODIZER***
 260 - (QC7-Inspect Chemical Conversion Coat)
 270 - (Spray Paint / NDT Room) ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5200249 2-PAINT AS PER DWG AND

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QSI005 4.2.2.4 PAINT BATCH: 5213125

280 - (QC14- Inspect Spray Paint)

282 - ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND

QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT

BATCH: _____

284 - C OF C IS REQUIRED

290 - (Assemble as per dwg) 1-Install FWD and AFT cap seal with sikaflex-241 / 291 B 5200625 Exp: 20107Start time: 8:00 AM Finish time: 8:00 PM 2-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon B 1133690

300 - (QC5- Inspect part completeness to step on W/O)

310 - (Identify as per dwg & Stock Location: _____)

320 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6028-195	Crosstube Material, 7075-T73/T73511	1 pcs (1 ea)	110-Skidtubes - 1	<u>5187596</u>
	Crossbolt Spacer	18 pcs (18 ea)	230-Skidtubes - 3 - B4B	<u>5148264</u>
	Crossbolt Spacer	12 pcs (12 ea)	230-Skidtubes - 3 - B4B	<u>5213968</u>
	Bolt	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5123445</u>
	Washer, Phenolic	6 pcs (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5164008</u>
D5483-041	Tow Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5199399</u>
D5484-041	Aft Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5200349</u>
NAS1149C0332R	Washer	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5218154</u>

M.H. 012836

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D6028-195	1	15	0
230-Skidtubes - 3 - B4B	D5512-1	12	118	0
	D5518-1	18	236	0
	AN3C5A	6	1,084	0
	D3672-1	6	1,669	0
	D5483-041	1	10	0
	D5484-041	1	9	0
	NAS1149C0332R	6	2,780	0

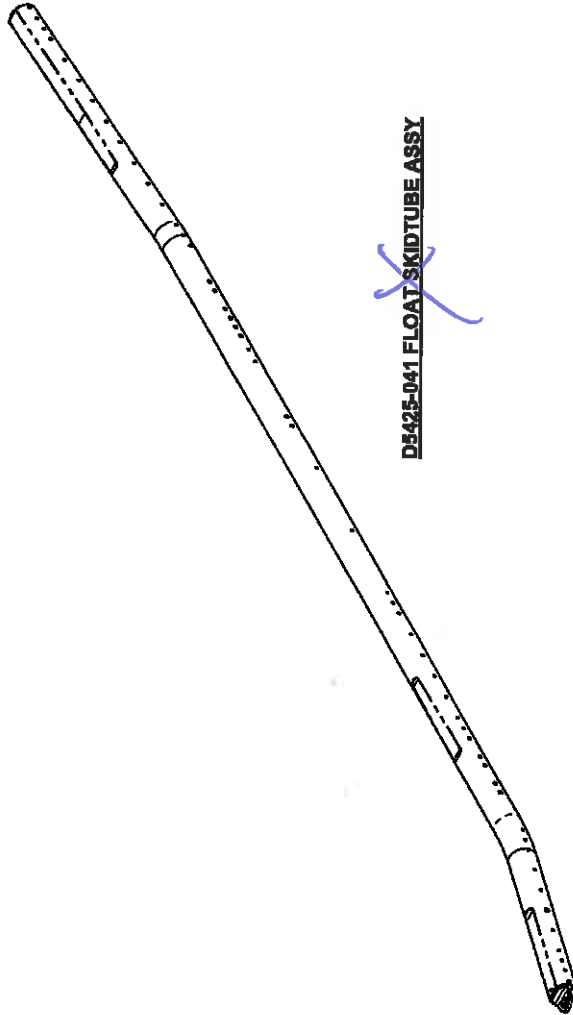
Part Specifications

Specifications could not be found.

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QTY	PN	DESCRIPTION
X	D5425-041	FLOAT SKIDTUBE ASSY
0	D3672-1	WASHER
1	D5425-1	FLOAT SKIDTUBE
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5612-1	CROSSBOLT SPACER
37	D5618-1	CROSSBOLT SPACER
6	ANSC5A	BOLT
8	NAS1149C0332R	WASHER

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196264 NUS
1906-11



D5425-041 FLOAT SKIDTUBE ASSY

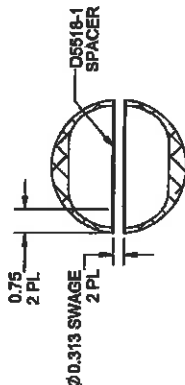
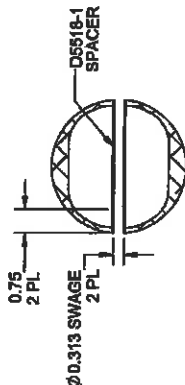
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2018 AUG 16 47
ELEN 16-11-16

B		CHANGE HOLE SIZE TO IMPROVE OFF-AXIS SWAGING IN HOLE IN SKIDTUBE (INCHES IN PICTORIAL UPDATE DUE TO CHANGES IN D5425-1)		NO	18.02.05
A		NEW ISSUE		NO	17.07.19
REV.		DESCRIPTION		DATE	
DESIGN		NO		DART AEROSPACE USA, INC.	
DRAWN		NO		EUGENE, OR	
CHECKED		ZF		DRAWING NO.	
MFG. APPR.		DD		D5425	
APPROVED		NO		TITLE	
DE APPR.		DS-1		412 FLOAT SKIDTUBE	
DATE		18.02.05		SCALE	
				NTS	

APPROVED

REV. B
SHEET 1 OF 10
SCALE
NTS

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DART AEROSPACE USA, INC.

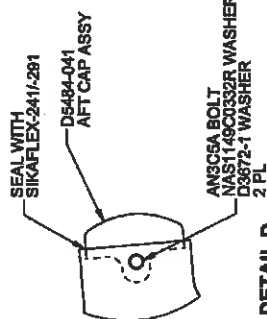


AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.377 HOLES ONLY:

- 1. INSERT D5618-1 SPACER**
- 2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002**
- 3. TRIM / GRIND FLUSH PER QSI 002**

AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. WET INSTALL D5612-1 SPACER PER QSI 002
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



DETAIL D
SCALE 4X

SECTION B-B
SCALE 4X
37 PL

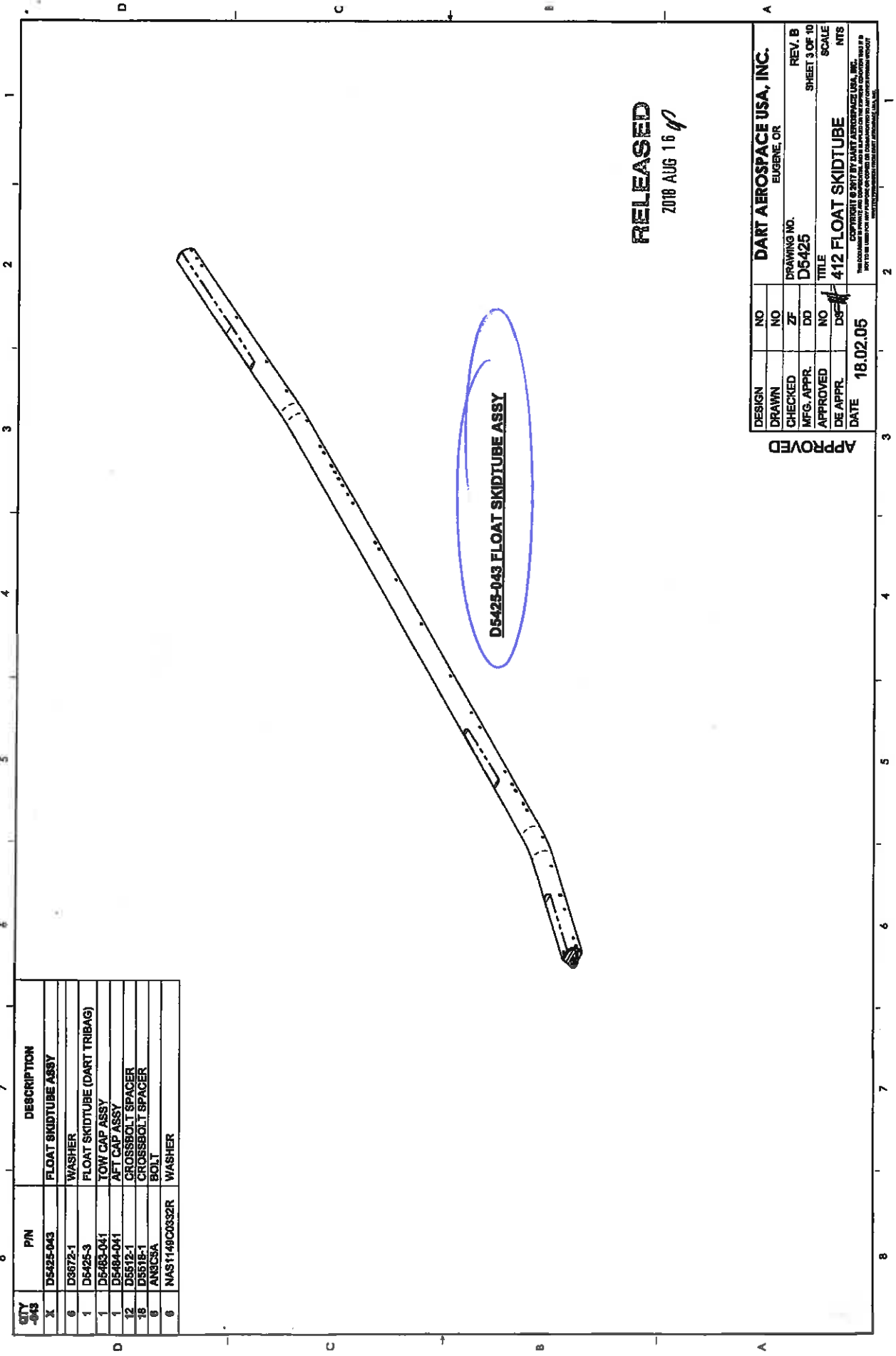
SECTION C-C
SCALE 4X
12 PL

DETAIL A
SCALE 4X

RELEASED
2018 AUG 16

DESIGN	NO	DART AEROSPACE USA, INC.		REV. B	SHEET 2 OF 10
DRAWN	NO	EUGENE OR			
CHECKED	2F	DRAWING NO.	D5425	SCALE	NTS
MFG. APPR.	DD	TITLE	412 FLOAT SKID/TUBE		
APPROVED	DS- 1	DATE	18.02.05		

NOTES:
 (1) MATERIAL: N/A
 (2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 PAINT PER DART QSI 005 4.2.1.3.3
 PAINT PER DART QSI 005 4.2.2.4
 (3) TOLERANCES: PER DART QSI 013 UNLESS OTHERWISE NOTED
 (4) UNITS: INCHES UNLESS OTHERWISE NOTED
 (5) BREAK SHARP EDGES: N/A
 (6) IDENTIFICATION: IDENTITY PER QSI 044 6.1
 (7) WEIGHT: 54.5lbs
 (8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"



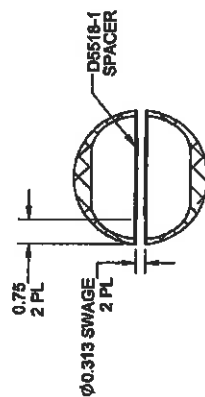
RELEASED
2018 AUG 16 *qp*

QTY	P/N	DESCRIPTION
1	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5483-041	TOW CAP ASSY
1	D5494-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
16	D5518-1	CROSSBOLT SPACER
6	ANCSA	BOLT
6	NAS1149C032R	WASHER

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DO	D5425	SHEET 3 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	D5425	412 FLOAT SKIDTUBE	NTS
DATE	18.02.05		

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SECTION G-G
SCALE 4X
12 PL

SECTION F-F
SCALE 4X
18 PL

AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.377 HOLES ONLY:

- 1. INSERT D5518-1 SPACER**
- 2. SWAGE TO Ø0.313 X 0.75 DEEP PER QSI 002**
- 3. TRIM / GRIND FLUSH PER QSI 002**

AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

- 1. WET INSTALL D512-1 SPACER PER QSI 002**
- 2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002**
- 3. TRIM / GRIND FLUSH PER QSI 002**

DETAIL H
SCALE 4X

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2018 AUG 16

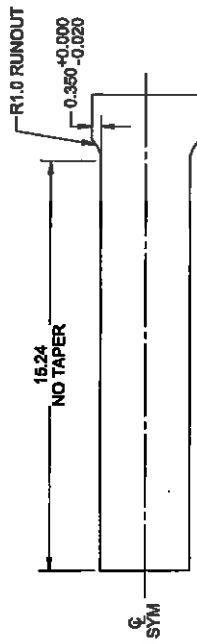
NOTES:

- (1) MATERIAL: N/A
- (2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
- (3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- (4) UNITS: INCHES UNLESS OTHERWISE NOTED
- (5) BREAK SHARP EDGES/N/A
- (6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- (7) WEIGHT: 54.3lbs
- (8) COAT ALL FASTENERS WITH LPS "LPS PROCCYON"

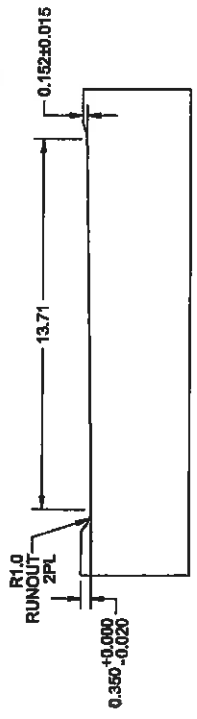
DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	
MFG. APPR.	DD	D5425	
APPROVED	NO	TITLE	
DE APPR.	DS	412 FLOAT SKIDTUBE	
DATE	18.02.05	REV. B SHEET 4 OF 10 SCALE NTS	

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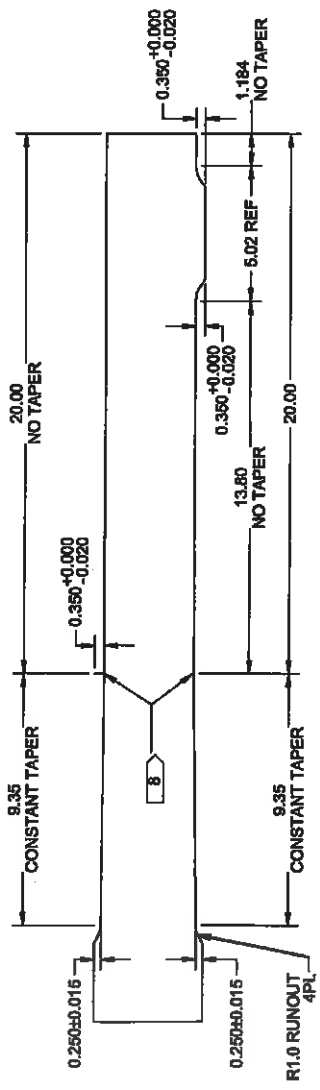
8 7 6 5 4 3 2 1



DETAIL AE
SCALE 3X



DETAIL AF
SCALE 3X



DETAIL AG
SCALE 3X

RELEASED
2018 AUG 16 q

DESIGN	NO	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	NO	EUGENE, OR	
CHECKED	ZF	NO	DRAWING NO.	REV. B
MFG. APPR.	DD	NO	D5425	SHEET 10 OF 10
APPROVED	NO	NO	TITLE	SCALE
DE APPR.	DD	NO	412 FLOAT SKIDTUBE	NTS
DATE	18.02.05	NO	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. ALL RIGHTS RESERVED. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.	

APPROVED

8 7 6 5 4 3 2 1

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐				DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				Date: _____ Sequence #: _____		QTY Affected: _____		MRB (QSI042) _____											
Description Work Order Deviation						Disposition																			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY																			
						Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐					Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐					Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐					Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				
						Other/Details: _____																			
Completed By _____						Lead hand / Supervisor _____						QC / QA Coordinator _____													